



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D5552-1**  
**Job Sheet 170801**



Part No: D5552-1

Job Qty: 8 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 2/26/18

Type: SOLD

Description:

Note: DWG D5552 REV.A SHEET 1 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 90    | Start up Operation     | 8 Ea  |            |          | 0.00      | 0.00    | Start Up Waterjet     |           | 2/18/01/29   |
| 100   | Waterjet               | 8 pcs |            |          | 0.00      | 4.67    | Waterjet1             |           | 2/18/01/29   |
| 110   | QC                     | 8 pcs |            |          | 0.00      | 0.00    | QC2 Waterjet-4        |           | 2/18/01/29   |
| 120   | CNC Vertical Machining | 8 pcs |            |          | 0.00      | 33.90   | HAAS1-1               |           | SBL 18/02/18 |
| 130   | QC                     | 8 pcs |            |          | 0.00      | 0.00    | QC2 Machining-4       |           | SBL 18/02/18 |
| 140   | QC                     | 8 pcs |            |          | 0.00      | 0.00    | QC8 Machining-4       |           | mm 18/02/18  |
| 150   | HandFinish             | 8 pcs |            |          | 0.00      | 2.16    | HandFinish1           |           | 18-02-23-8   |
| 160   | QC                     | 8 pcs |            |          | 0.00      | 0.00    | QC7-5                 |           | 18-02-26-8   |
| 170   | Powdercoat             | 8 pcs |            |          | 0.00      | 0.89    | Powdercoat1           |           | 18-02-26-8   |
| 180   | QC                     | 8 pcs |            |          | 0.00      | 0.00    | QC3                   |           | 18-02-26-8   |
| 190   | Packaging              | 8 pcs |            |          | 0.00      | 0.00    | Packaging3-2          |           | 18-02-26-8   |
| 200   | QC21-SA                | 8 Ea  |            |          | 0.00      | 0.00    | QC21                  |           | 18-02-26-8   |

Part Op 100 - 1-Cut contour and pocket as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 120 - Face and drills holes as per dwg Dwg Rev: 170

170 - \*\*\*Mask holes or blow out access powdercoat in holes\*\*\* START TIME: 4:15 OVEN TEMPERATURE: 320° FINISH TIME: 4:15 18-02-26-8

### Job BOM

| Part / Item          | Component Name          | Quantity            | Operation             | Container |
|----------------------|-------------------------|---------------------|-----------------------|-----------|
| M6061T6B0.750X04.000 | 6061-T6 Bar .750 X 4.00 | 5.3280 ft (.666 ea) | 90-Start up Operation |           |

### Part Specifications

Specifications could not be found.

Plex 1/19/18 1:02 PM dart.poulin.mario

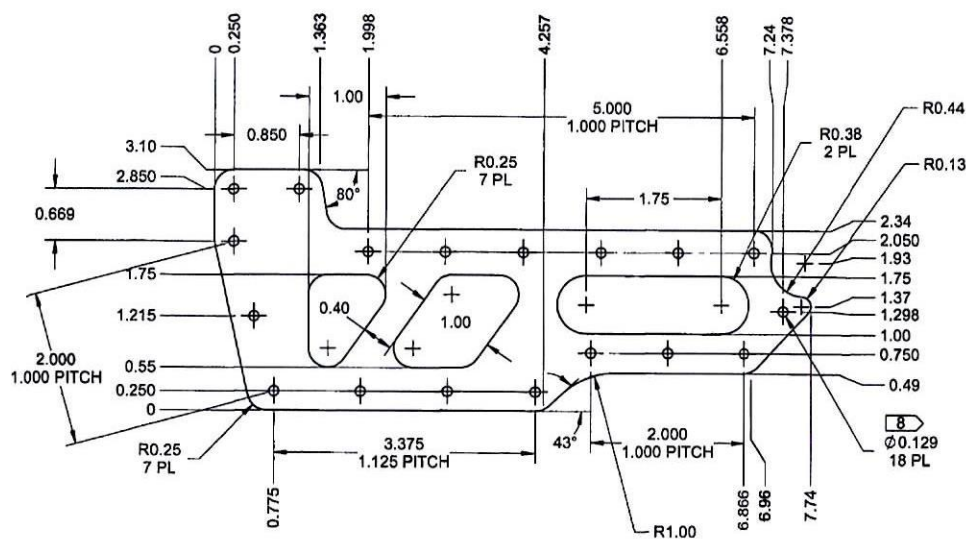
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                                 |  |                       |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------|--|-----------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | Date: _____ |  | AGAINST DEPARTMENT/PROCESS<br>elvid-tube <input type="checkbox"/> Cross tube <input type="checkbox"/> Water Jet <input type="checkbox"/> Engineering <input type="checkbox"/><br>Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Quality <input type="checkbox"/><br>Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Other <input type="checkbox"/><br>Composite <input type="checkbox"/> Supplier <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | active : _____                                  |  | MRB (QSI042) Approval |  |
| <div style="position: relative; height: 100px;"> <div style="position: absolute; top: 0; right: 0; text-align: right;"> <b>PART NO:</b><br/>Original Serial #: D5552-1<br/>Revision: S036861<br/>Operation: S036861<br/>Change No: S036861<br/><br/> <b>Start up Operation</b><br/>Job No: 170801<br/>01/30/18           </div> <div style="position: absolute; top: 50%; left: 50%; transform: translate(-50%, -50%) rotate(-45deg);"> <b>PART NO:</b><br/>Original Serial #: D5552-1<br/>Revision: S036861<br/>Operation: S036861<br/>Change No: S036861           </div> <div style="position: absolute; top: 0; left: 0;"> <b>Spacer</b><br/>  </div> <div style="position: absolute; bottom: 0; right: 0; transform: rotate(90deg); transform-origin: bottom right;"> <b>Dart Aerospace Ltd.</b><br/>           1270 Aberdeen Street<br/>           Hawkesbury, ON K6A 1K7<br/>           TEL: 1 613 632-5200<br/>           Email: sales@dartaero.com<br/>           www.dartaerospace.com         </div> </div> |  |             |  | <b>Disposition</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | Completed By                                    |  |                       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | Lead hand / Supervisor<br>Approval Verification |  |                       |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | QC / QA Coordinator<br>Approval                 |  |                       |  |
| <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <b>Ror</b><br/>           Environment <input type="checkbox"/><br/>           Design <input type="checkbox"/><br/>           Doc/Data <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Pre <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Internal Transport <input type="checkbox"/><br/>           Tribal Knowledge <input type="checkbox"/><br/>           LOA <input type="checkbox"/><br/>           Substation <input type="checkbox"/><br/>           Past Expiry Date <input type="checkbox"/><br/>           Misidentified <input type="checkbox"/> </div> <div style="width: 45%;">           Rushing <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Past Due <input type="checkbox"/> </div> </div>                    |  |             |  | <b>FAULT CATEGORY</b><br><div style="display: flex; justify-content: space-between;"> <div style="width: 45%;">           Temperature/Cure <input type="checkbox"/><br/>           up <input type="checkbox"/><br/>           n/Route <input type="checkbox"/><br/>           ken/Damage/Defect <input type="checkbox"/><br/>           ection Incomplete/Unqualified <input type="checkbox"/><br/>           ontamination <input type="checkbox"/><br/>           ountersink <input type="checkbox"/><br/>           Cut Too Short <input type="checkbox"/><br/>           Instructions Incomplete/Unclear <input type="checkbox"/><br/>           Drill Holes <input type="checkbox"/> </div> <div style="width: 45%;">           Power Loss/Surge <input type="checkbox"/><br/>           Folio/Program <input type="checkbox"/><br/>           Grain <input type="checkbox"/><br/>           Weld <input type="checkbox"/><br/>           Wrong Stock Pulled <input type="checkbox"/><br/>           Out of Sequence <input type="checkbox"/><br/>           Off-set <input type="checkbox"/><br/>           Mislabeled <input type="checkbox"/><br/>           Fit/Function <input type="checkbox"/><br/>           Misaligned/off center <input type="checkbox"/> </div> </div> |  |                                                 |  |                       |  |
| <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;">           Wave/... <input type="checkbox"/><br/>           Marks/Chatter <input type="checkbox"/> </div> <div style="width: 45%;">           Positioned Wrong <input type="checkbox"/><br/>           Outside Dimensions <input type="checkbox"/><br/>           Over/Under tolerance <input type="checkbox"/><br/>           Part Incorrect <input type="checkbox"/><br/>           Part Lost/Missing <input type="checkbox"/><br/>           Part Moved <input type="checkbox"/><br/>           Drawing <input type="checkbox"/><br/>           Finish <input type="checkbox"/><br/>           Misread <input type="checkbox"/><br/>           Turning Sequence <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                         |  |             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                                 |  |                       |  |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                                 |  |                       |  |







**D5552-1 SPACER**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.87 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5552-1 REV. A.SLDPRT

RELEASED  
2018-01-08  
EN 17-793

APPROVED

| A NEW ISSUE |             | RF                                                                                                                                                                                                                                                                                        | 17.07.24     |
|-------------|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| REV.        | DESCRIPTION | BY                                                                                                                                                                                                                                                                                        | DATE         |
| DESIGN      | RF          | <b>DART AEROSPACE USA, INC.</b><br>EUGENE, OR                                                                                                                                                                                                                                             |              |
| DRAWN       | RF          |                                                                                                                                                                                                                                                                                           |              |
| CHECKED     | WK          | DRAWING NO.                                                                                                                                                                                                                                                                               | REV. A       |
| MFG. APPR.  | RQ          | <b>D5552</b>                                                                                                                                                                                                                                                                              | SHEET 1 OF 2 |
| APPROVED    | HS          | TITLE                                                                                                                                                                                                                                                                                     | SCALE        |
| DE APPR.    | DS          | <b>SPACER</b>                                                                                                                                                                                                                                                                             | NTS          |
| DATE        | 17.07.24    | COPYRIGHT © 2017 BY DART AEROSPACE USA, INC.<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |              |